



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2932-1

Job Sheet 180950



Part No: D2932-1

Job Qty: 4 ea

Part Name: Saddle LH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev, (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/31/18	0.00	0.00	Start Up Machining-1		SBL 18/07/20
100	CNC Vertical Machining	4 pcs		7/31/18	0.63	4.00	HAAS1-2		SBL 18/07/27
110	Mill Conv	4 pcs		7/31/18	0.00	0.67	Mill Conv 1		SBL 18/07/27
120	QC	4 pcs		7/31/18	0.00	0.00	QC1		SBL 18/07/27
130	QC	4 pcs		7/31/18	0.00	0.00	QC8 Machining-1		anml 18/08/09
140	HandFinish	4 pcs		7/31/18	0.00	0.18	HandFinish1		D.R 18/08/09
150	Powdercoat	4 pcs		7/31/18	0.00	0.20	Powdercoat1		18-08-13
160	QC	4 pcs		7/31/18	0.00	0.00	QC3		AUG 17 2018
170	Packaging	4 pcs		7/31/18	0.00	0.00	Packaging3-1		21 AUG 24 2018
180	QC21-SA	4 Ea		7/31/18	0.00	0.00	QC21		21 AUG 24 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & Descriptions: attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA012.

150 - START TIME: 8:00 AM OVEN TEMPERATURE: 320°F 8:30 AM

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	5011638 5096744

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
DART Aerospace Ltd. 1270 Aberdeen Street Windsor, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/26/18 Container No: S096747 Part: D2932 - 1 Job No: 180950 Serial No/Batch: S096747 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
<table style="width:100%;"> <tr> <td style="width:25%;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:25%;"> No Re-ver ☐ Operator ☐ Offset/Se ☐ Supplier ☐ Training ☐ Use for Te ☐ Poor Infor ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%;"> Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%;"> Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:25%;"> Misaligned/off center ☐ Misread ☐ Turning Sequence ☐ </td> <td style="width:25%;"> s/Surge ☐ ram ☐ ck Pulled ☐ uence ☐ </td> <td style="width:25%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>						Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-ver ☐ Operator ☐ Offset/Se ☐ Supplier ☐ Training ☐ Use for Te ☐ Poor Infor ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Misaligned/off center ☐ Misread ☐ Turning Sequence ☐	s/Surge ☐ ram ☐ ck Pulled ☐ uence ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
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OTHER : _____ OTHER : _____																					

DART AEROSPACE LTD	Work Order: 180 950
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.118	.118	.118	.118		
B	0.100	0.140		.118	.118	.117	.117		
C	0.100	0.140		.117	.116	.117	.117		
D	0.210	0.230		.225	.226	.226	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.237	.238		
N	0.100	0.140		.122	.122	.122	.121		
O	0.540	0.560		.551	.551	.550	.551		
P	0.490	0.510		.503	.502	.501	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.500	2.500	2.500		
S	0.240	0.270		.255	.256	.256	.255		
T	0.100	0.180		.127	.130	.130	.128		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

DAS

Measured by:	57
Date:	9-89 18/07/27

Audited by:	mmf
Date:	18/08/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

